



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D4073-3
Job Sheet 169723



Part No: D4073-3

Job Qty: 20 ea

Part Name: Door Hinge Backing Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/20/17

Job Tracking No:

Due Date: 12/22/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B SHEET 2 IPP Rev:A 10.06.08 new issue DD verf:EC IPP REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/21/17	12/21/17	0.00	0.00	Start Up Waterjet		OK 18/01/18
100	Waterjet	20 pcs	12/21/17	12/21/17	0.00	0.61	Waterjet1		OK 18/01/18
120	QC	20 pcs	12/21/17	12/21/17	0.00	0.00	QC8		38
130	HandFinish	20 pcs	12/21/17	12/21/17	0.00	0.34	HandFinish1		2018/01/15 JEL
140	Powdercoat	20 pcs	12/22/17	12/22/17	0.00	0.19	Powdercoat1		BAS BAS-93
150	QC	20 pcs	12/22/17	12/22/17	0.00	0.00	QC3		38 11 JAN 24 2018
160	Packaging	20 pcs	12/22/17	12/22/17	0.00	0.00	Packaging3	57073	AT 89-89 18/01/20
170	QC21-SA	20 Ea	12/22/17	12/22/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum POWDER COAT: Start Time: 1.30 Oven

Temperature: 300 Finish Time: 2.00 MB8407

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.063	1	215	0	0

DART
AEROSPACE
S030833



Door Hinge Backing Plate

PART NO: D4073-3

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 01/10/18

Job No: 169723

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Hinge Backing Plate	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	
2	Door Hinge Backing Plate	2.000Inches ± 0.030	2.030 1.970		
3	Door Hinge Backing Plate	1.320Inches ± 0.010	1.330 1.310		
4	Door Hinge Backing Plate	0.340Inches ± 0.030	0.370 0.310		
5	Door Hinge Backing Plate	0.350Inches ± 0.030	0.380 0.320		
6	Door Hinge Backing Plate	1.800Inches ± 0.030	1.830 1.770		
7	Door Hinge Backing Plate	1.100Inches ± 0.010	1.110 1.090		
8	Door Hinge Backing Plate	0.063Inches ± 0.010	0.073 0.053		

Plex 1/9/18 10:06 AM dart.leroux.jason